

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007117**Date Inspected:** 08-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI Inspectors: N/A

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Prior to Caltrans QA Inspectors' concurring with issuance of OBG deck plate closed rib green tag releases a review of the ultrasonic inspection database is performed to verify all closed rib tack weld repair locations have been ultrasonically accepted. Today this QA Inspector, Mr. Paul Dawson, performed data entry of ultrasonic inspection information from the field generated Ultrasonic inspection data sheets onto the common drive computer database for the following OBG deck panels: DP206-001, DP368-001, DP315-001, DP152-001, DP342-001, DP123-001, DP123-002, DP422-001, DP342-002, DP295-001, DP178-001, DP124-002, DP339-002, DP126-002 and DP396-001.

OBG Bay 5

This QA Inspector performed random magnetic particle (MT) inspection of OBG Cross Beam CB4 welds FB204-001-079, FB204-001-080, FB204-001-081, FB204-001-082, FB204-002-079, FB204-002-080, FB204-002-045, FB205-001-046, FB205-001-047, FB205-001-048, FB205-001-013, FB205-001-016, FB205-001-019, FB205-001-022, FB205-002-045, FB205-002-046, FB205-002-047, FB205-002-048,

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FB205-002-013, FB205-002-016, FB205-002-019, FB205-002-022, FB205-003-019, FB205-003-022, FB205-003-013 and FB205-003-016. These welds had previously been MT inspected and accepted by ZPMC inspection personnel. The QA Inspector observed the welds that were MT inspected by this QA Inspector appear to comply with project specifications. For additional information on these inspections see the TL6028 Magnetic Particle Test Report.

This QA Inspector along with other QA Inspectors performed random visual inspections of lift 2 corner plates inside South Tower Lift 2. The QA Inspector observed the 52 meter elevation corner plate has a below flush condition at the end of the weld. See the photograph below for additional information.



### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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